

Work Order ID 68965

Tuesday, April 26, 2011 1:47:29 PM

Page 1

Item ID: D2582

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Leg Assembly

Start Date: 4/26/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-26 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2582	Rev B

100	Small Fab	0.00
Small Fab	Memo	0.00
Small Fab	Assemble as per Dwg D2582 and	

110	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

120	Identify as per dwg & Stock Location:	0.00
Packaging	Memo	0.00
Packaging		

SB 4/05/19 (12)

SB 11/05/19

(12)

WA

AE 11-06-2 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/6/10
MF
11-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, April 26, 2011 1:47:35 PM

Page 1

Work Order ID: 68965

Parent Item: D2582

Parent Item Name: Step Leg Assembly



Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:F Removed Manufacturing 05-11-07 JLM
 IPP Rev:G Added part # to Sub 06-08-10 JLM
 IPP Rev H New pick list 08.01.11 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2278 Step Leg		Manufactured	No			100	Each	0.0000	2	24		4/5/19	
D2278RevF Step Leg		Manufactured	No			100	Each	0.0000	2	24		4/5/19	
D2279 Step Spacer		Manufactured	No			100	Each	14.0000	1	12		4/5/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		14							
				48090C		14							
D2322 Step Spacer		Manufactured	No			100	Each	24.0000	1	12		4/5/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		24							
				67611		24							
D3720-1 Step Spacer		Manufactured	No			100	Each	5.0000	1	12		4/5/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5							
				62234		5							

B 69035 (23)

B 62222 (17)

B 69287 (7)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 68965

Parent Item: D2582

Parent Item Name: Step Leg Assembly

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 12.00

Required Qty: 12.00

D3720-2 Manufactured No

100 Each

7.0000

1

12



Step Spacer

Location

Loc Qty

Loc Code

GA

7

62235

7

MS20470AD4-4 Purchased No

100 Each

4,364.000

22

264



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST139

1818

117423

1818

ST319

2546

116188

2317

116391

229

MS20470AD4-5 Purchased No

100 Each

1,611.000

4

48



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1611

116410

41

116893

1570

EP 4/05/19
B69288 (5X)

EP 4/05/19

101
163

EP 4/05/19

48

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SHOP COPY 3
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68963
 PL 11-09-26

D2278 STEP LEG
 (2 PLACES)

MS20470AD4-4 RIVET
 (5 PLACES PER SIDE)
 (INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
 (6 PLACES PER SIDE)
 (INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
 (2 PLACES)

MS20470AD4-5 RIVET
 (2 PLACES)

D3720-2 STEP SPACER

D3720-1 STEP SPACER

C/SINK ON INSIDE
 GRIND RIVET FLUSH TO
 SURFACE AS REQUIRED
 (BOTH SIDES)

RELEASED
 06-01-10

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION		BY DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LS	DRAWING NO.	REV. B
MFG. APPR.		D2582	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP LEG ASSEMBLY	NTS
DATE	07.12.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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